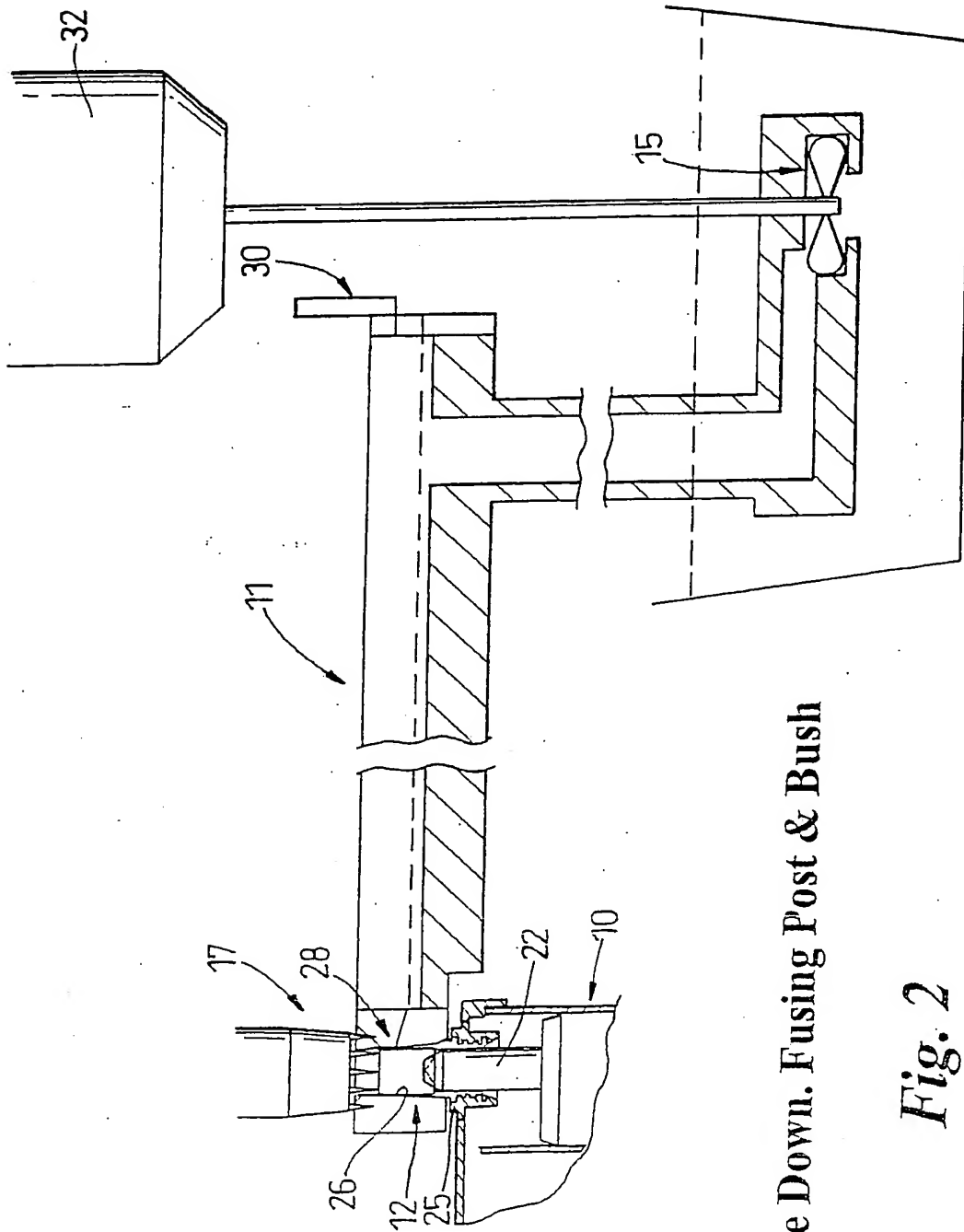


Start Position. Mold Located  
on Bush, Probe Up

Fig. 1

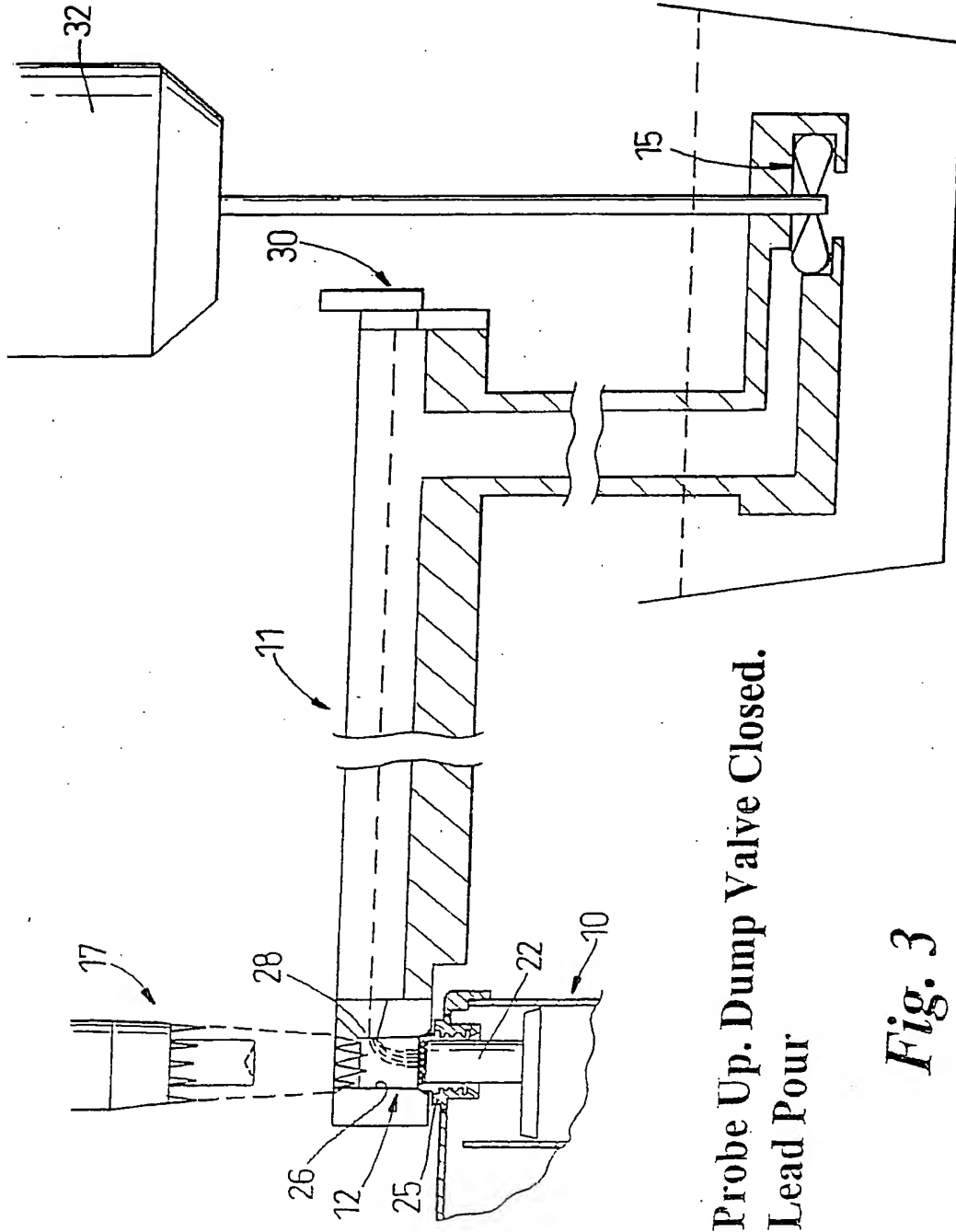
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Probe Down. Fusing Post & Bush

Fig. 2

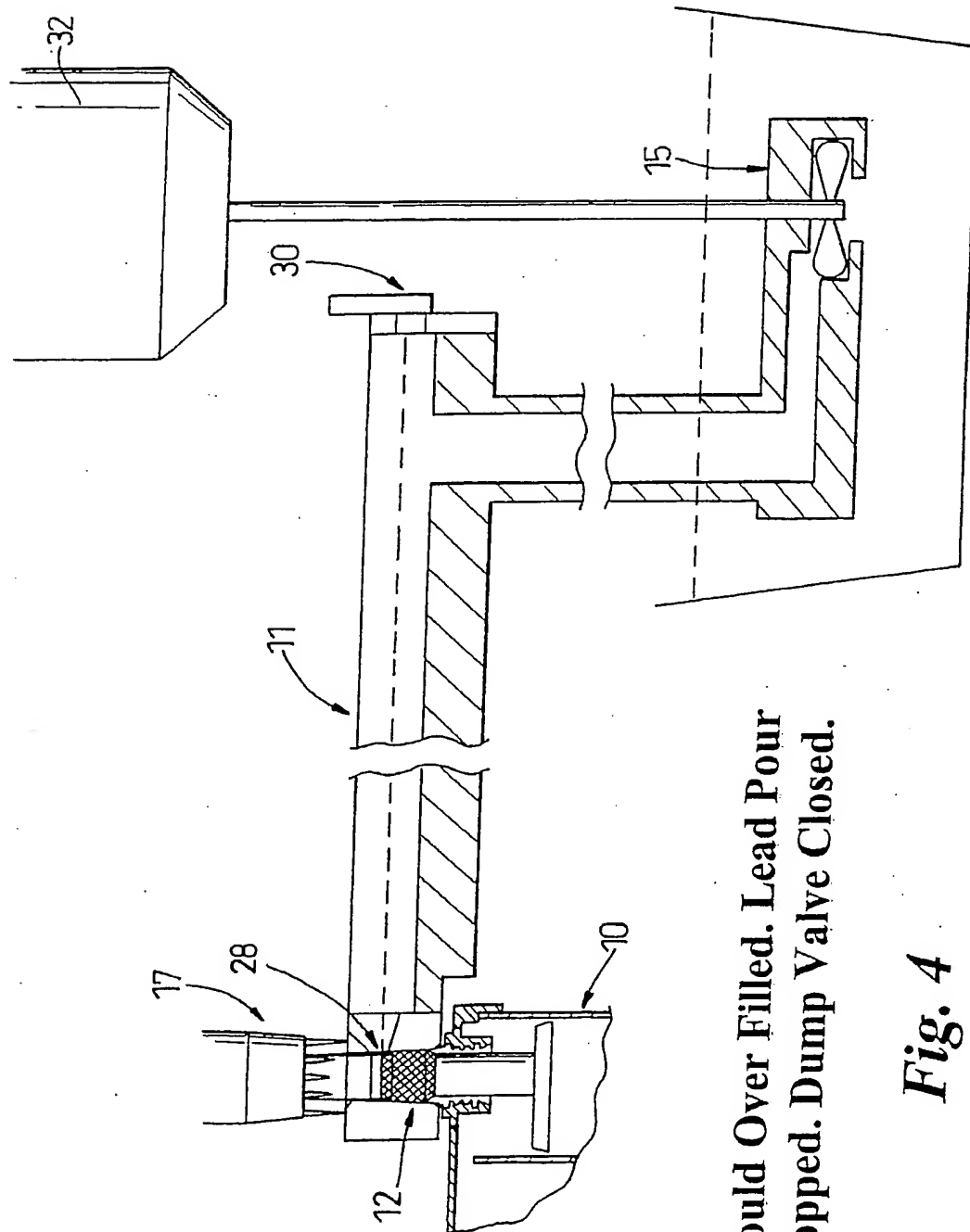
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Probe Up. Dump Valve Closed.  
Lead Pour

*Fig. 3*

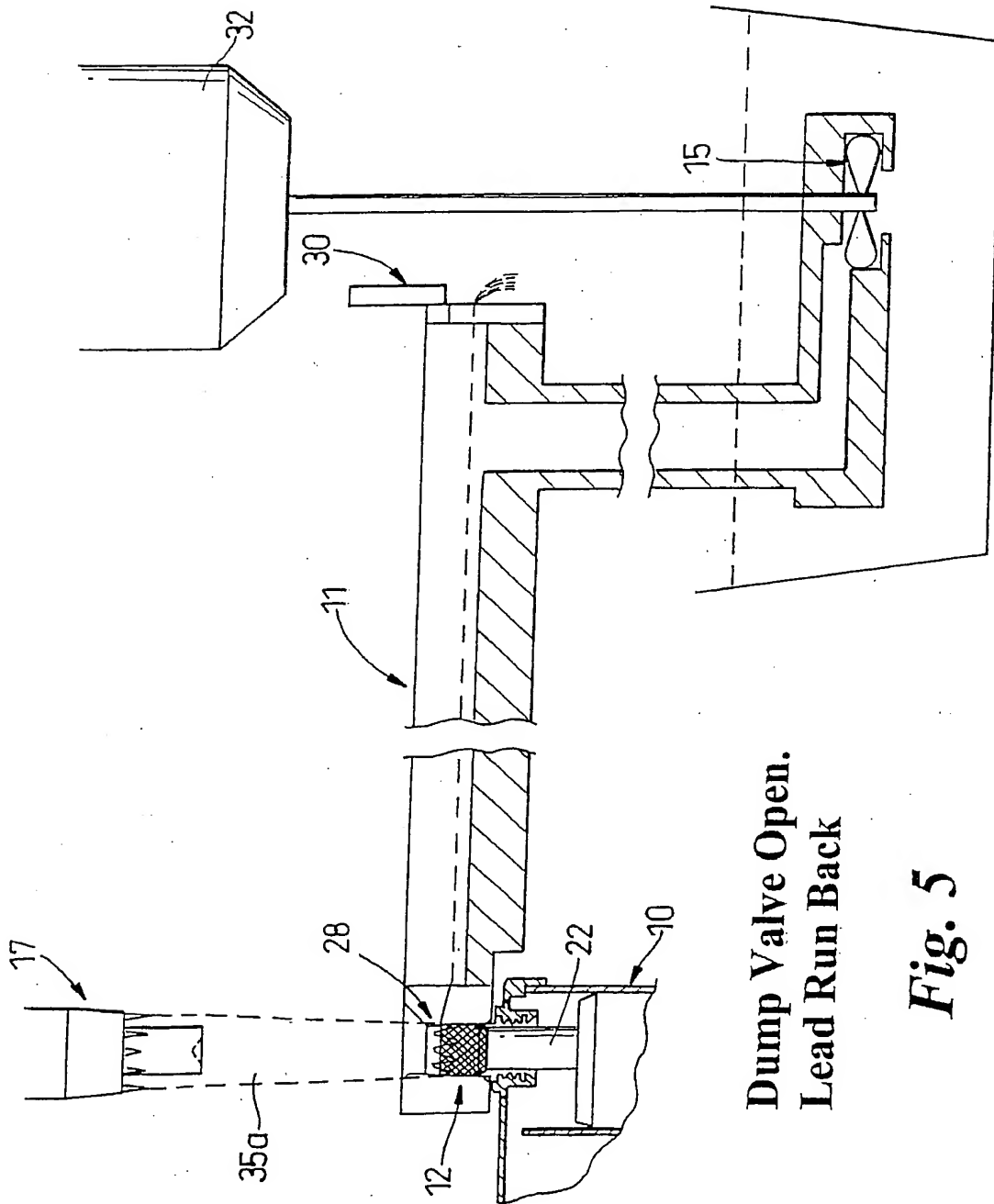
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Mould Over Filled. Lead Pour  
Stopped. Dump Valve Closed.

*Fig. 4*

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Dump Valve Open.  
Lead Run Back

*Fig. 5*